

# Work Order ID 61241

Wednesday, August 11, 2010 11:35:03 AM



Page 1

Item ID: D3535-15

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 8/12/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 8/26/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: MW

Date: 10-8-17

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3535	Rev B

100



FLOW WATER JET

Waterjet

Memo

0.00

10-8-17

FLOW CNC Waterjet

304 .040

1-Cut as per Dwg D3535  Dwg Rev: B  Prog Rev: R  2-  
Deburr if necessary

(B)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

10-8-17

Quality Control

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

S100817

(X/B)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 61241**

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Page 2

Item ID: D3535-15

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326□2-Form  
joggle as per Dwg D3535 using Jig DT8158□3-Identify as D3535-15

*8/10/08/18 13*

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

*13*

*100818*

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

*M112588*  
0.00

Powdercoat

Powder Coating

Memo

START TIME: *11:30*FINISH TIME: *12:00*

OVEN TEMPERATURE:

*13*

*BK 10 8-23,*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 61241**

Wednesday, August 11, 2010 11:35:03 AM



Page 3

Item ID: D3535-15

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 8/12/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 8/26/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

160



QC

Quality Control

Operation  
Description

QC3- Inspect Part Finish

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

=7M 16/08/23

X/3 &amp;

170



Packaging

Packaging

Identify as per dwg &amp; Stock Location:

FP-8

0.00

M 16/08/23

X/3 &amp;

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

16/08/23 JJ

MF  
10-8-23

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

# Picklist Print

Wednesday, August 11, 2010 11:35:02 AM

Page 1

Work Order ID: 61241



Parent Item: D3535-15



Parent Item Name: Wearshoe

Start Date: 8/12/2010

Required Date: 8/26/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-15 JLM  
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	19.5987	1.0205	10.74211		 B10-8-17	

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT	16.1522	
114574	16.1522	
MAT20	3.4465	
112885	2.7475	
113062	0.699	
105440		115440

(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	67241
Description: Wearshoe	Part Number:	D3535-15
Inspection Dwg: D3535 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.888	x		V HP-02	
2.000	+/-0.010	2.000	x		V	
5.650	+/-0.010	5.660	x		T HD-01	
9.150	+/-0.010	9.150	x		T	
14.400	+/-0.010	14.400	x		T	
19.650	+/-0.010	19.650	x		T	
24.900	+/-0.010	24.900	x		T	
30.150	+/-0.010	30.150	x		T	
33.650	+/-0.010	33.650	x		T	
35.650	+/-0.010	35.650	x		T	
39.150	+/-0.010	39.150	x		T	
Ø0.188	+0.005/-0.001	.190	x		V	
24.00	+/-0.030	24.00	x		T	
16.00	+/-0.030	16.00	x		T	
8.00	+/-0.030	8.00	x		T	
5.00	+/-0.030	5.00	x		T	
0.300	+/-0.010	.301	x		V	
0.300	+/-0.010	.303	x		V	
0.038	+/-0.010	.034	x		V	

Measured by:	H3	Audited by:	S	Prototype Approval:	N/A
Date:	10-8-17	Date:	10/08/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	E

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

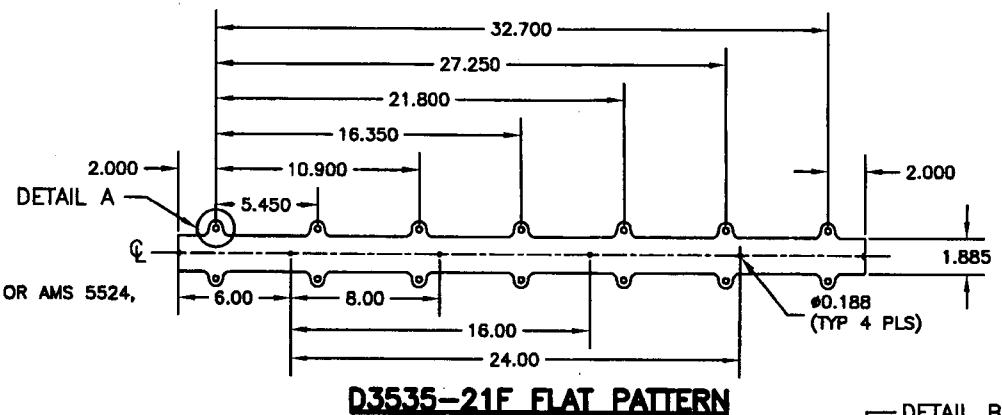
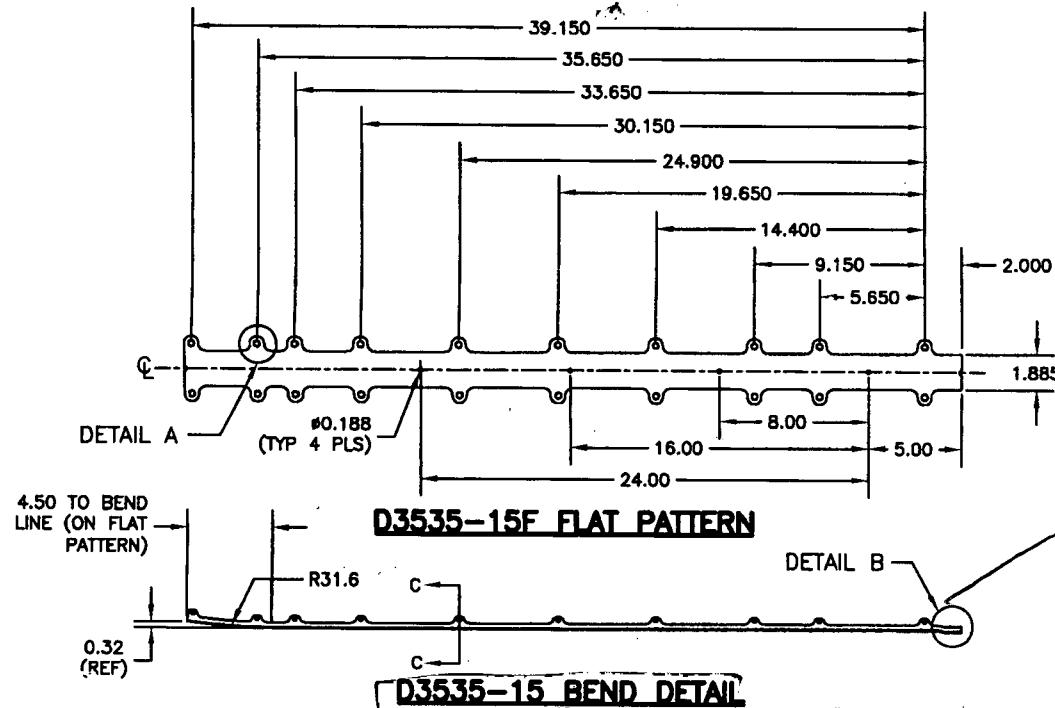
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

**DART**RELEASED  
07.04.17

DESIGN <b>CB</b>	DRAWN BY <b>#4</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA
CHECKED <b>#</b>	APPROVED <b>#</b>	DRAWING NO. <b>D3535</b>
DATE <b>07.04.17</b>	TITLE <b>WEARSHOE</b>	REV. B SHEET 2 OF 7 SCALE <b>1:10</b>

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>CB</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE	SCALE 1:1

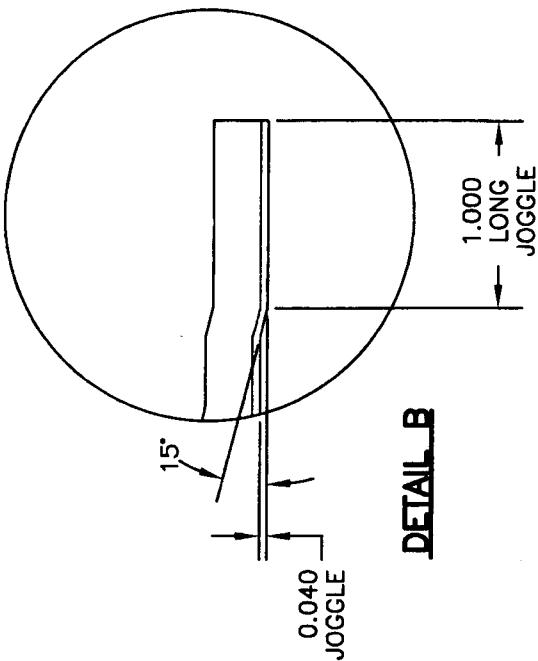
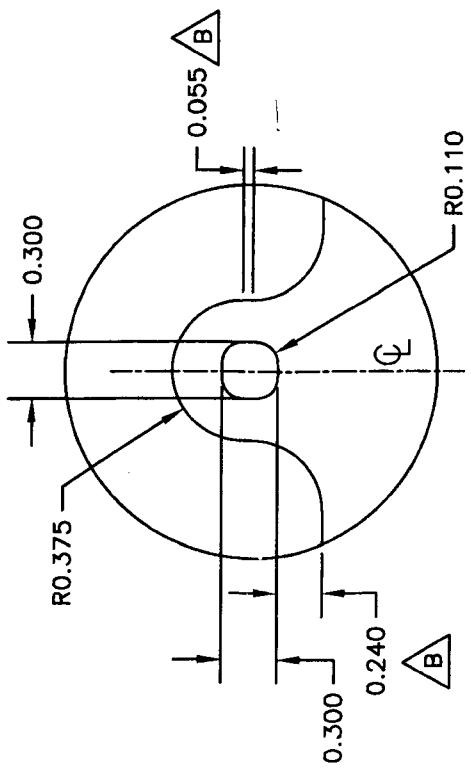
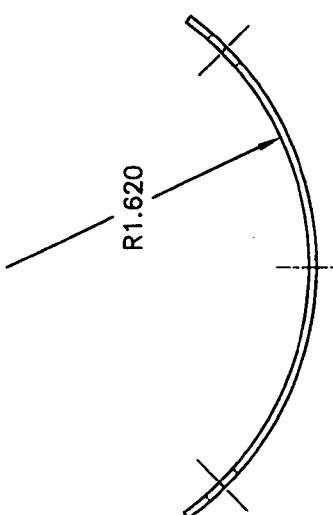
REV. B

SHEET 7 OF 7

RELEASED

07.04.24 *[Signature]*

# 61241

**DETAIL B****DETAIL A****SECTION C-C**

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